Shp 21/10

Work Order ID 63089

October 20, 2010 3:12:03 PM

Item ID: D3891-4 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Gasket

Start Date: 10/20/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/21/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10/20/10 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D3891	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
Waterjet	**Memo**	0.00				B10-10-21			
FLOW CNC Waterjet	1-Cut as per Dwg D3891 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B10-10-21			
Quality Control									

(2)

Work Order ID 63089

October 20, 2010 3:12:03 PM

Item ID: D3891-4 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Gasket

Start Date: 10/20/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/21/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				2			10/10/21
QC	**Memo**	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: GA	0.00							
Packaging	63086		SS 10/10/21			(2)			
Packaging	**Memo**	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							10/10/21
QC	**Memo**	0.00							
Quality Control									

NF
10-10-21

Picklist Print

October 20, 2010 3:12:02 PM

Work Order ID: 63089

Parent Item: D3891-4

Parent Item Name: Gasket

Start Date: 10/20/10 **Required Date:** 10/21/10

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	784.7000	2.963	6.237895			

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Location	Loc Qty	Loc Code
MAT	500	
114937	500	
MAT052	284.7	
112335	284.7	

IPR 10-10-21

112335

(2)

DART AEROSPACE LTD	Work Order:	63889
Description: Gasket	Part Number:	D3891-4
Inspection Dwg: D3891 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.8	+/-0.100	16.750	✓		T RO1	
25.4	+/-0.100	25.375	✓		T	
0.125	+/-0.010	.131	✓		V RO2	

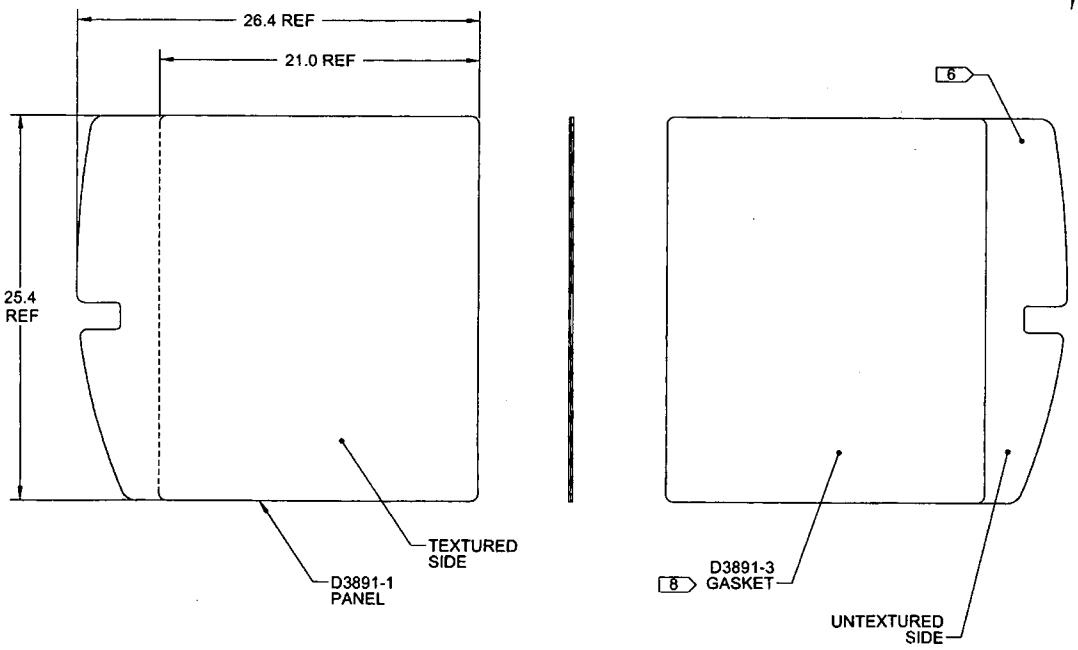
Measured by:	RB	Audited by:		Prototype Approval:	N/A
Date:	10-10-21	Date:	10/10/21	Date:	N/A

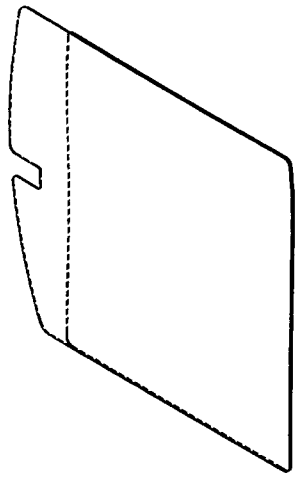
Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 43089
09-10-20





RELEASED
09/05/18

D3891-041 PANEL, FWD LH

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
7) WEIGHT: 3.67 lbs
8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	09.05.01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3891	REV. A
MFG. APPR.			SHEET 1 OF 6
APPROVED		TITLE PANEL, FWD	SCALE NTS
DE APPR.			
DATE	09.05.01		

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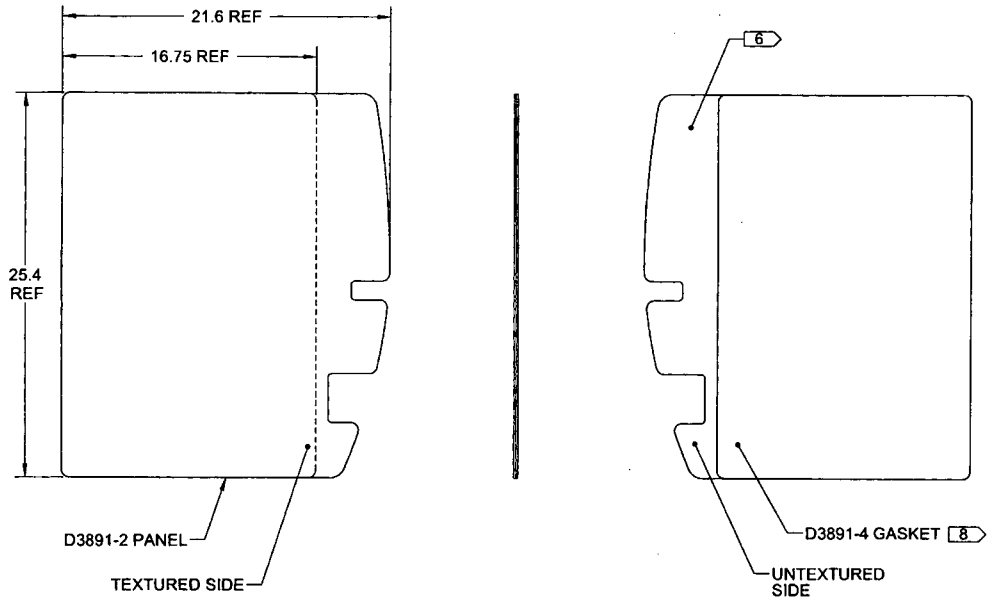
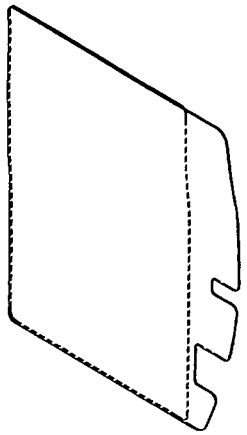
PARTS LIST

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE





w/o 63889

RELEASED 09/05/11

D3891-042 PANEL, FWD RH

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
7) WEIGHT: 2.93 lbs
8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
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APPROVED		TITLE PANEL, FWD SCALE NTS
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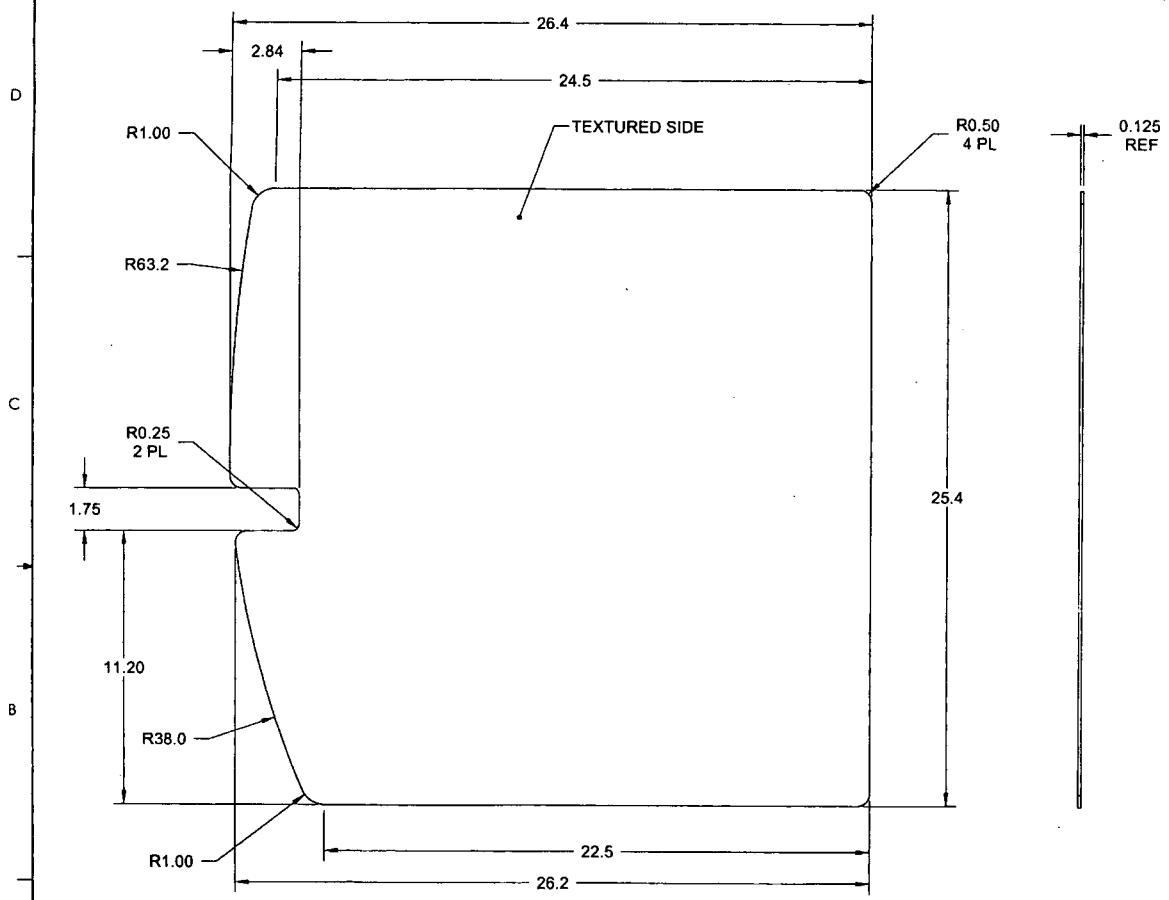

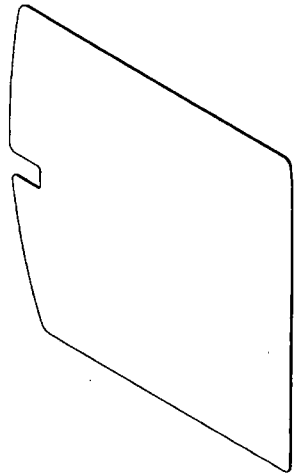

w/o 63089

RELEASED
07/06/16

D3891-1 PANEL

NOTES:
1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 3.46 lbs

DESIGN		DART AEROSPACE LTD
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MFG. APPR.		SHEET 3 OF 6
APPROVED		TITLE PANEL, FWD SCALE NTS
DE APPR.		
DATE 09.05.01		

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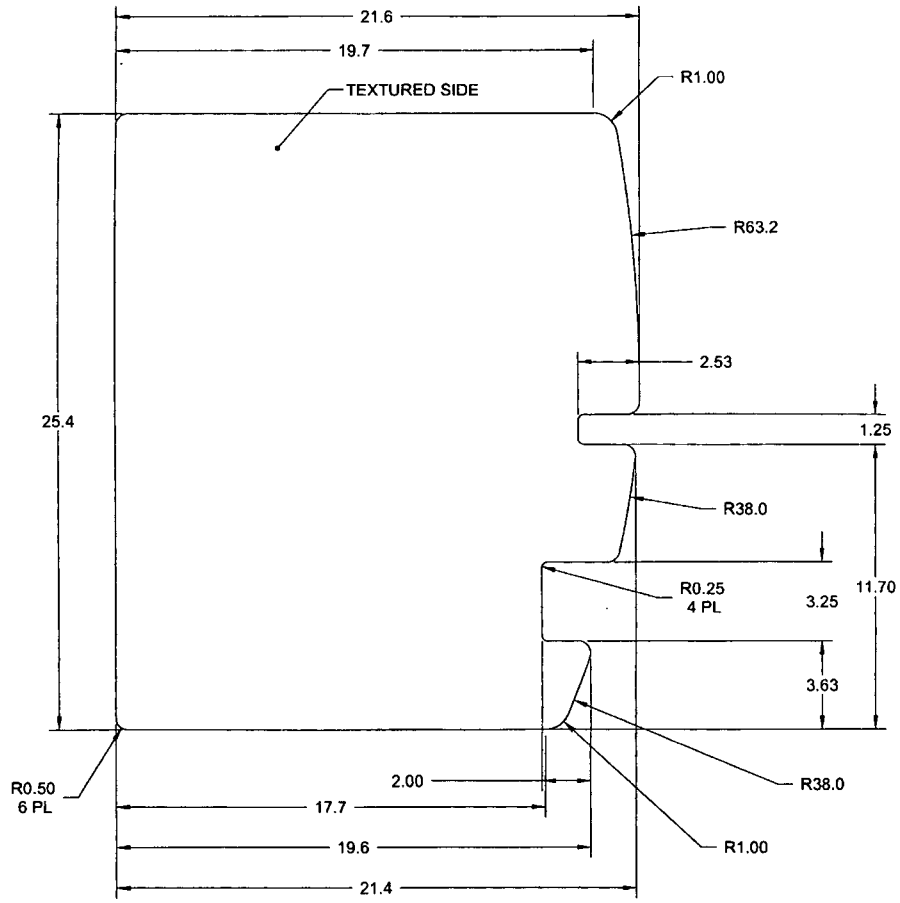

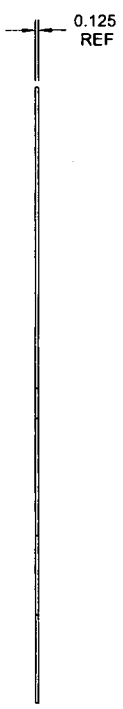

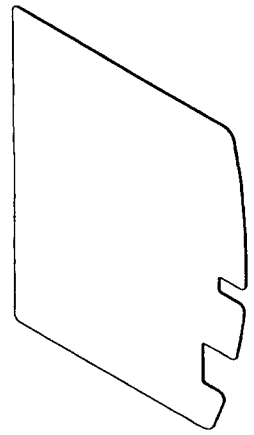

w/o 43089

RELEASED
09/06/16

D3891-2 PANEL

NOTES:
1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.77 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
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CHECKED		DRAWING NO. D3891 REV. A
MFG. APPR.		SHEET 4 OF 6
APPROVED		TITLE PANEL, FWD SCALE NTS
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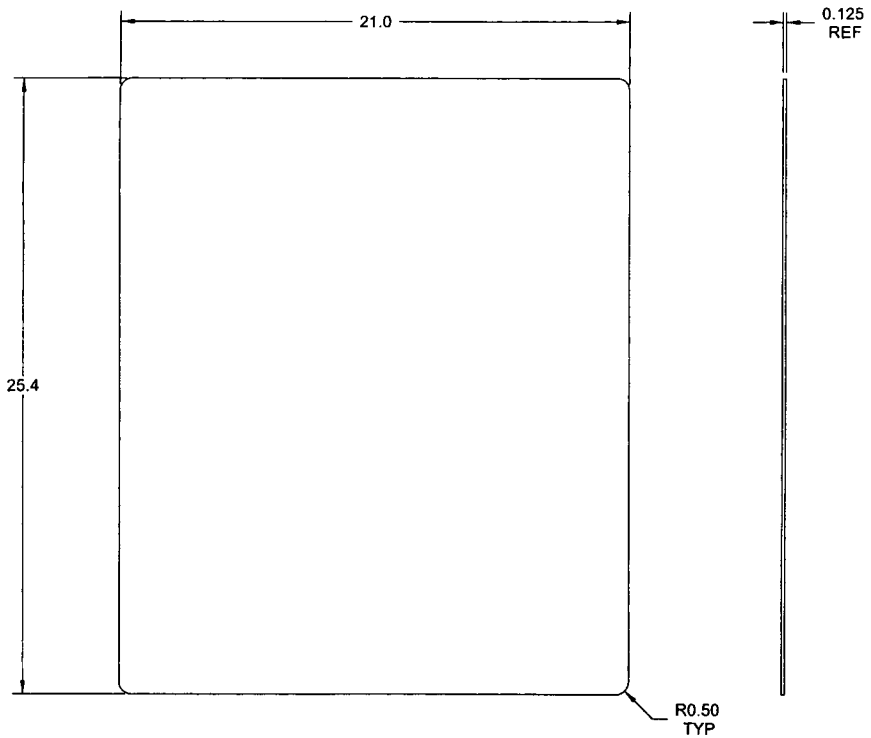

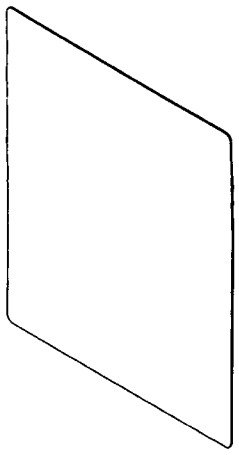

D3891-3 GASKET

w/o 43089

RELEASED
09/06/16

NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.21 lbs

DESIGN		DART AEROSPACE LTD
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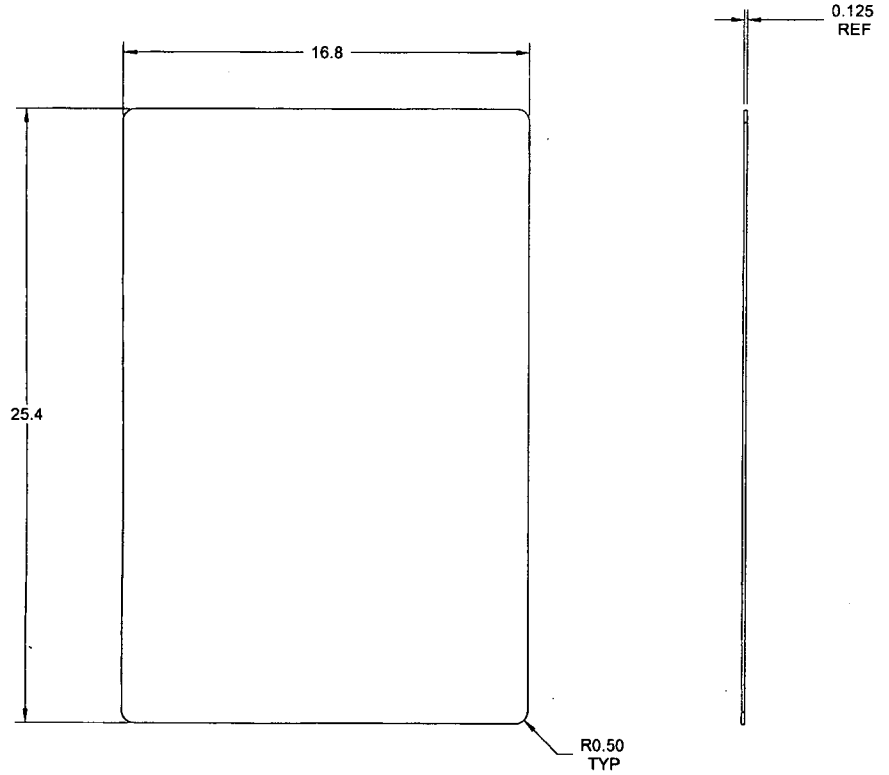

D3891-4 GASKET

w/o 43089

RELEASED
9/16/16

NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.17 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3891 — REV. A
MFG. APPR.		SHEET 6 OF 6
APPROVED		TITLE: PANEL, FWD — SCALE: NTS
DE APPR.		
DATE 09.05.01		

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